Page 1 January-24-13 11:56:11 AM Item ID: D2182B035 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Cushion **Start Date:** 1/24/13 **Start Qty:** 50.00 \*50\* Cust Item ID: Required Date: 2/07/13 Req'd Qty: 50.00 **Customer:** Reference: Run Process Plan: MLJ Date: /3-01-24 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D2182 Rev C 100 0.00 \*100\* Packaging Packaging 0.00 Memo Packaging Cut as per dwg 110 QC6- Inspect dimensions to drawing \*110\* QC Memo Quality Control 120 Identify as per dwg & Stock Locatio \*120\* Packaging 0.00 Memo Packaging

NCR: Y	⁄es	/ No				WORK ORDER NON-C	CON	FORM	MANCE / UPI	DATE			
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	- - No.					Rework Scrap Use-as-is Work Order Update		I Thern	Skig-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	lr	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				7	•								
						<del></del>	AUL	CATE	GORY		<del></del>		
Landi	$\overline{}$					General					1		1_
]	$\vdash$	Bending			o,,	Bend BOM/Route	$\vdash$	Grain			Ovalized	talarana	Pressure/Forced
		Centre No	ot Concer	itric to	U/S	BOM/Route	1 1	Hardwa	ire		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Burrs

Date:

Weld

Other

Wrong Stock Pulled

DQA:

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-24-13 11:56:11 AM Item ID: D2182B035 Accept \*N900040100\* Setup Start \*NS1\* **Revision ID:** Item Name: Cushion Stop **Start Date:** 1/24/13 **Start Qty: 50.00** \*50\* **Cust Item ID:** Required Date: 2/07/13 Req'd Qty: 50.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 130 QC21- Final Inspection - Work Order Release 0.00 \*130\* MUJ 13-01-31 MUJ 13-01-31 QC 0.00 Memo Quality Control

DQA:	 Date:	

## WORK ORDER NON-CONFORMANCE / UPDATE

NCR: \	⁄es	/ No				WORK ORDER NON-	CON	NFORI	MANCE / UP		QA Closed:	Date	::
Work Orde	or:					DISPOSITION				AGAINST DE			·
Part N	-					Rework Scrap	]	ı	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	-					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite		re/Packaging Supplier	Other
Root					Descri	ption of work order update	Ti	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC inspector
Doc/Data	Ш												
Equip/Tooling	Ш											٠	
Operator	Ц												
Material	Ц												
Setup	Н												
Other	Н								1				
Process	Н												
Supplier	Н												
Training	Н						ļ						
Unapproved	<u> </u>		l	L	i		<u> </u>	T CATE	GORY		<u> </u>	<u> </u>	<u>i</u>
Landi	ng G			<del></del>	<del>,</del>	General	AUL	CAIL	GOKT				
Landi		Bending				Bend	Г	Grain			Ovalized	. [	Pressure/Forced
	_	Centre No	ot Concer	ntric to	o/s	BOM/Route	$\vdash$	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	-	Cracks			~~   <del>-</del>	Broken/Damaged		i	ion Incomplete		Part Incorre	<del> </del>	Weld
	-	Crushed/0	Crimped.			Burrs		1	tions Incomplete/	'Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	$\vdash$	Cuffs	•			Contamination		Mainte	•		Part Moved	٠ ـ	J
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	
	П	Inspection	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	'Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n	Drawing		Out of	Calibration				
		Turning So	equence			Finish		Out of	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

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## **Picklist Print**

January-24-13 11:56:15 AM

Work Order ID: 96342

Parent Item: Parent Item Name: Cushion

D2182B035

\*96342\*

\*D2182B035\*

**Start Date: 1/24/13** 

Required Date: 2/07/13

Start Qty: 50.00

Required Qty: 50.00

Comments:

B99.03.02Reformat DM

as per revC DD verf:EC

IPP Rev:C 10.11.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	 Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B		Manufactured	No	 	100	f	329.0400	0.2916	14.58		)	
*D2182R*								**		5	/ 	· · · · · · · · · · · · · · · · · · ·

Location

Loc Qty Loc Code 329.04 329.04

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	coi	NFORI\	/IANCE / UP	DATE	0.6.61====	D	
		***			<del></del>		T***			QA Closed:	Date:	
Manle Onde					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er:				Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	do.				Scrap	1		Machining	Small Fab	l Pro	d. Eng. Coor.	Quality
ruici	····				Use-as-is	1	•	noforming	Finishing	4	re/Packaging	Other
NCR N	No.				Work Order Update	1 '	ŧ	Large Fab	Composite	1	Supplier	
					,	_						•
Root					ption of work order update		Initial		ction	Sign &		ļ
Cause	Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling							ļ			ļ		
Operator							İ					
Material							į					
Setup								l				
Other								I				
Process												
Supplier						İ		1				
Training												
Unapproved		<u> </u>								ļ	<u> </u>	
						AUI	LT CATE	<u> GORY</u>				
Landi	ng Gear				General		7			7	<b></b>	<b>-</b>
	Bending				Bend	L	Grain		_	Ovalized	<u> </u>	Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route	L	Hardwa		<u> </u>	Over/Under	<b>⊢</b>	Temperature/Cure
	Cracks				Broken/Damaged		4	on Incomplete		Part Incorre	_	Weld
	Crushed	/Crimped			Burrs	L	Instruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	<u>_</u>	Mainte	nance		Part Moved		
	Heat Tre	at			Countersink	L	Mislabe	led		Positioned \	Wrong	
	Inspection	on Strip in	Tube		Cut Too Short		Misread	1		Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

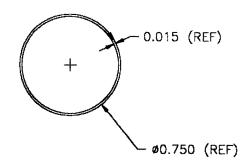
Drill Holes

Drawing

Finish Folio

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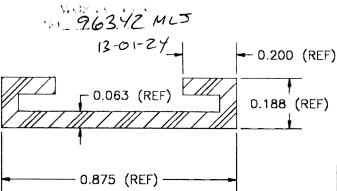
## 97/05/10 DS



D2182-050, HEAT SHRINK LENGTH

> EG: 3.5 LONG: D2182-035 10 LONG: D2182-100

MATERIAL: RAYCHEM RNF-100-3/4-CL HEAT SHRINKABLE INSULATION SLEEVING



W-WHITE B-BLACK D2182W050, RUBBER CUSHION LENGTH

> EG: WHITE 3.5 LONG: D2182W035 BLACK 10 LONG: D2182B100

MATERIAL: SANTOPRENE 101-73 CONFORMS TO MIL-R-3065





	$ \omega $	VICTORIA INTERNATIONAL AIRPORT, CANADA REV.	
Charles of the Control of the Contro	CHECKEDY APPROVED	D2182 SHEET 1 OF	REV.
•	DATE	THE THE	Š
	Jan. 6, 1995	RUBBER CUSHION	
	В 97:04:07	97:04:07 ADD MATERIAL SPECIFICATION	
	C 97:05:14	97:05:14 ADD HEAT SHRINK	